**Work Order ID 87707** *87707* 

*July-25-12 1:16:25 PM*

**Item ID:** D4006-5 **Accept** *N900040100* **Setup** **Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Foam

**Start Date:** 7/10/12 **Start Qty:** 10.00 *10* **Cust Item ID:**

**Required Date:** 7/27/12 **Req'd Qty:** 10.00 *10* **Customer:**

**Reference:**

**Run** **Start** *NR1*

**Approvals:** **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

**QC:** ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|

| Draw Nbr | Revision Nbr |
|---|---|
| D4006 | B |

(15)

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Insp. Stamp |
|---|---|---|---|
| 100<br>*100*<br>Waterjet<br>FLOW CNC Waterjet | **Memo**<br>1-Cut as per Dwg<br>Dwg Rev: B<br>Prog Rev: B<br><br>2-Deburr if necessary | 0.00<br>0.00 | RB 12-7-25 |
| 110<br>*110*<br>QC<br>Quality Control | QC2- Inspect parts off machine FAI/FAIB<br>**Memo** | 0.00<br>0.00 | RB 12-7-25 |

DQA: ________ Date: ____________

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

| Work Order: ____________<br>Part No. ____________<br>NCR No. ____________ | **DISPOSITION**<br>Rework ☐<br>Scrap ☐<br>Use-as-is ☐<br>Work Order Update ☐ | **AGAINST DEPARTMENT/PROCESS**<br>Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐<br>Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐<br>Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐<br>Large Fab ☐ Composite ☐ Supplier ☐ ☐ |
|---|---|---|

| **Root Cause** | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|
| Doc/Data ☐ | | | | | | | | | |
| Equip/Tooling ☐ | | | | | | | | | |
| Operator ☐ | | | | | | | | | |
| Material ☐ | | | | | | | | | |
| Setup ☐ | | | | | | | | | |
| Other ☐ | | | | | | | | | |
| Process ☐ | | | | | | | | | |
| Supplier ☐ | | | | | | | | | |
| Training ☐ | | | | | | | | | |
| Unapproved ☐ | | | | | | | | | |

**FAULT CATEGORY**

| **Landing Gear** | **General** | | | |
|---|---|---|---|---|
| ☐ Bending | ☐ Bend | ☐ Grain | ☐ Ovalized | ☐ Pressure/Forced |
| ☐ Centre Not Concentric to O/S | ☐ BOM/Route | ☐ Hardware | ☐ Over/Under tolerance | ☐ Temperature/Cure |
| ☐ Cracks | ☐ Broken/Damaged | ☐ Inspection Incomplete | ☐ Part Incorrect | ☐ Weld |
| ☐ Crushed/Crimped. | ☐ Burrs | ☐ Instructions Incomplete/Unclear | ☐ Part Lost/Missing | ☐ Wrong Stock Pulled |
| ☐ Cuffs | ☐ Contamination | ☐ Maintenance | ☐ Part Moved | |
| ☐ Heat Treat | ☐ Countersink | ☐ Mislabeled | ☐ Positioned Wrong | |
| ☐ Inspection Strip in Tube | ☐ Cut Too Short | ☐ Misread | ☐ Power Loss/Surge | ☐ Other |
| ☐ Ripples in Bend | ☐ Drill Holes | ☐ Offset | | |
| ☐ Torque Waves in Extrusion | ☐ Drawing | ☐ Out of Calibration | | |
| ☐ Turning Sequence | ☐ Finish | ☐ Out of Sequence | | |
| ☐ Wave/Twist in Tube | ☐ Folio | ☐ Outside Dimensions | | |

**Work Order ID** 87707 *87707* 

*July-25-12 1:16:25 PM*

**Item ID:** D4006-5 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Foam

**Start Date:** 7/10/12 **Start Qty:** 10.00 *10* **Cust Item ID:**

**Required Date:** 7/27/12 **Req'd Qty:** 10.00 *10* **Customer:**

**Reference:**

**Run Start** *NR1* **Stop** *NR2*

**Approvals:** **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

**QC:** ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 120 *120* QC Quality Control | QC8- Inspect parts - second check<br>Memo | 0.00 SMB 12.7.25<br>0.00 | DAS 16 S-83 12/4/25 | | | 16 | | | |
| 170 *170* Packaging Packaging | Identify as per dwg & Stock Location: ST086<br>Memo | 0.00<br>0.00 | | | | 16 | | | 12/07/25 JB |
| 180 *180* QC Quality Control | QC21- Final Inspection - Work Order Release<br>Memo | 0.00<br>0.00 | | | | | MLJ | 12/07/26 | |

MLJ 12/07/26

DQA: ________ Date: ______________

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

| Work Order: ____________ | **DISPOSITION** | **AGAINST DEPARTMENT/PROCESS** | | | |
|---|---|---|---|---|---|
| Part No. ____________ | Rework ☐ | Skid-tube ☐ | Crosstube ☐ | Water Jet ☐ | Engineering ☐ |
| NCR No. ____________ | Scrap ☐ | Machining ☐ | Small Fab ☐ | Prod. Eng. Coor. ☐ | Quality ☐ |
| | Use-as-is ☐ | Thermoforming ☐ | Finishing ☐ | Rec/Store/Packaging ☐ | Other ☐ |
| | Work Order Update ☐ | Large Fab ☐ | Composite ☐ | Supplier ☐ | ☐ |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|
| Doc/Data ☐ | | | | | | | | | |
| Equip/Tooling ☐ | | | | | | | | | |
| Operator ☐ | | | | | | | | | |
| Material ☐ | | | | | | | | | |
| Setup ☐ | | | | | | | | | |
| Other ☐ | | | | | | | | | |
| Process ☐ | | | | | | | | | |
| Supplier ☐ | | | | | | | | | |
| Training ☐ | | | | | | | | | |
| Unapproved ☐ | | | | | | | | | |

## FAULT CATEGORY

| Landing Gear | General | | | |
|---|---|---|---|---|
| ☐ Bending | ☐ Bend | ☐ Grain | ☐ Ovalized | ☐ Pressure/Forced |
| ☐ Centre Not Concentric to O/S | ☐ BOM/Route | ☐ Hardware | ☐ Over/Under tolerance | ☐ Temperature/Cure |
| ☐ Cracks | ☐ Broken/Damaged | ☐ Inspection Incomplete | ☐ Part Incorrect | ☐ Weld |
| ☐ Crushed/Crimped. | ☐ Burrs | ☐ Instructions Incomplete/Unclear | ☐ Part Lost/Missing | ☐ Wrong Stock Pulled |
| ☐ Cuffs | ☐ Contamination | ☐ Maintenance | ☐ Part Moved | |
| ☐ Heat Treat | ☐ Countersink | ☐ Mislabeled | ☐ Positioned Wrong | |
| ☐ Inspection Strip in Tube | ☐ Cut Too Short | ☐ Misread | ☐ Power Loss/Surge | ☐ Other |
| ☐ Ripples in Bend | ☐ Drill Holes | ☐ Offset | ____________ | |
| ☐ Torque Waves in Extrusion | ☐ Drawing | ☐ Out of Calibration | ____________ | |
| ☐ Turning Sequence | ☐ Finish | ☐ Out of Sequence | ____________ | |
| ☐ Wave/Twist in Tube | ☐ Folio | ☐ Outside Dimensions | | |

# Picklist Print



*July-25-12 1:16:24 PM*

**Work Order ID:** 87707

**Parent Item:** D4006-5

**Parent Item Name:** Foam

**Start Date:** 7/10/12 **Required Date:** 7/27/12

**Start Qty:** 10.00 **Required Qty:** 10.00

**Comments:** IPP rev A 09.12.22 new Issue Prelim EC verified by:DD IPP Rev:B 10.05.03 as per ECN10-562 DD verified by:EC IPP REV:C 12.03.07 AS PER DWG REV.B DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Furch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **M4111NS.125**<br>4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125" | | Purchased | No | | | 100 | sf | 323.0800 | **0.118** | **1.242105** | 2( | B(2-7-08 | |

| Location | Loc Qty | Loc Code |
|---|---|---|
| MAT052 | 323.08 | |
| 114937 | 323.08 | |

114937

(16)

DQA: ________ Date: ____________

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

| | | | |
|---|---|---|---|
| Skid-tube ☐ | Crosstube ☐ | Water Jet ☐ | Engineering ☐ |
| Machining ☐ | Small Fab ☐ | Prod. Eng. Coor. ☐ | Quality ☐ |
| Thermoforming ☐ | Finishing ☐ | Rec/Store/Packaging ☐ | Other ☐ |
| Large Fab ☐ | Composite ☐ | Supplier ☐ | ☐ |

| **Root Cause** | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|
| Doc/Data ☐ | | | | | | | | | |
| Equip/Tooling ☐ | | | | | | | | | |
| Operator ☐ | | | | | | | | | |
| Material ☐ | | | | | | | | | |
| Setup ☐ | | | | | | | | | |
| Other ☐ | | | | | | | | | |
| Process ☐ | | | | | | | | | |
| Supplier ☐ | | | | | | | | | |
| Training ☐ | | | | | | | | | |
| Unapproved ☐ | | | | | | | | | |

**FAULT CATEGORY**

| **Landing Gear** | **General** | | | |
|---|---|---|---|---|
| ☐ Bending | ☐ Bend | ☐ Grain | ☐ Ovalized | ☐ Pressure/Forced |
| ☐ Centre Not Concentric to O/S | ☐ BOM/Route | ☐ Hardware | ☐ Over/Under tolerance | ☐ Temperature/Cure |
| ☐ Cracks | ☐ Broken/Damaged | ☐ Inspection Incomplete | ☐ Part Incorrect | ☐ Weld |
| ☐ Crushed/Crimped | ☐ Burrs | ☐ Instructions Incomplete/Unclear | ☐ Part Lost/Missing | ☐ Wrong Stock Pulled |
| ☐ Cuffs | ☐ Contamination | ☐ Maintenance | ☐ Part Moved | |
| ☐ Heat Treat | ☐ Countersink | ☐ Mislabeled | ☐ Positioned Wrong | |
| ☐ Inspection Strip in Tube | ☐ Cut Too Short | ☐ Misread | ☐ Power Loss/Surge | ☐ Other |
| ☐ Ripples in Bend | ☐ Drill Holes | ☐ Offset | | |
| ☐ Torque Waves in Extrusion | ☐ Drawing | ☐ Out of Calibration | | |
| ☐ Turning Sequence | ☐ Finish | ☐ Out of Sequence | | |
| ☐ Wave/Twist in Tube | ☐ Folio | ☐ Outside Dimensions | | |

| DART AEROSPACE LTD | Work Order: | 87707 |
|---|---|---|
| | | |
| Description: Foam | Part Number: | D4006-5 |
| | | |
| Inspection Dwg: D4006 Rev: ~~A~~ B | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| 1.52 | +/-0.030 | 1.524 | 1 | | V RBZ | |
| 11.26 | +/-0.030 | 11.280 | 2 | | P RONSR | |
| 0.13 | +/-0.030 | .131 | 1 | | V | |
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| Measured by: | B |
|---|---|
| Date: | 12-7-24 |

| Audited by: | SMB DAS |
|---|---|
| Date: | 12-7-25 16 12/12/25 |

| Preliminary Approval: | |
|---|---|
| Date: | |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | 11.01.17 | New Issue | KJ | |

DQA: ________ Date: ________________

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

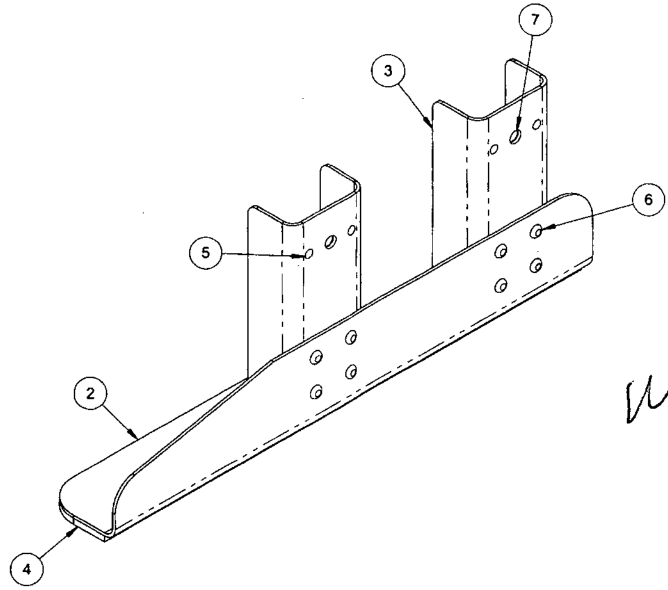
| Work Order: ________ | **DISPOSITION** | **AGAINST DEPARTMENT/PROCESS** | | | |
|---|---|---|---|---|---|
| Part No. ________ | Rework ☐ | Skid-tube ☐ | Crosstube ☐ | Water Jet ☐ | Engineering ☐ |
| NCR No. ________ | Scrap ☐ | Machining ☐ | Small Fab ☐ | Prod. Eng. Coor. ☐ | Quality ☐ |
| | Use-as-is ☐ | Thermoforming ☐ | Finishing ☐ | Rec/Store/Packaging ☐ | Other ☐ |
| | Work Order Update ☐ | Large Fab ☐ | Composite ☐ | Supplier ☐ | ☐ |

| **Root Cause** | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|
| Doc/Data ☐ | | | | | | | | | |
| Equip/Tooling ☐ | | | | | | | | | |
| Operator ☐ | | | | | | | | | |
| Material ☐ | | | | | | | | | |
| Setup ☐ | | | | | | | | | |
| Other ☐ | | | | | | | | | |
| Process ☐ | | | | | | | | | |
| Supplier ☐ | | | | | | | | | |
| Training ☐ | | | | | | | | | |
| Unapproved ☐ | | | | | | | | | |

**FAULT CATEGORY**

| **Landing Gear** | **General** | | | |
|---|---|---|---|---|
| ☐ Bending | ☐ Bend | ☐ Grain | ☐ Ovalized | ☐ Pressure/Forced |
| ☐ Centre Not Concentric to O/S | ☐ BOM/Route | ☐ Hardware | ☐ Over/Under tolerance | ☐ Temperature/Cure |
| ☐ Cracks | ☐ Broken/Damaged | ☐ Inspection Incomplete | ☐ Part Incorrect | ☐ Weld |
| ☐ Crushed/Crimped | ☐ Burrs | ☐ Instructions Incomplete/Unclear | ☐ Part Lost/Missing | ☐ Wrong Stock Pulled |
| ☐ Cuffs | ☐ Contamination | ☐ Maintenance | ☐ Part Moved | |
| ☐ Heat Treat | ☐ Countersink | ☐ Mislabeled | ☐ Positioned Wrong | |
| ☐ Inspection Strip in Tube | ☐ Cut Too Short | ☐ Misread | ☐ Power Loss/Surge | ☐ Other ________ |
| ☐ Ripples in Bend | ☐ Drill Holes | ☐ Offset | ________ | |
| ☐ Torque Waves in Extrusion | ☐ Drawing | ☐ Out of Calibration | ________ | |
| ☐ Turning Sequence | ☐ Finish | ☐ Out of Sequence | ________ | |
| ☐ Wave/Twist in Tube | ☐ Folio | ☐ Outside Dimensions | | |

| ITEM NO. | QTY. -041 | PART NUMBER | DESCRIPTION | JOHN CAMERON AVIATION PART NUMBER |
|---|---|---|---|---|
| 1 | X | D4006-041 | TANK TOP SUPPORT ASSEMBLY | JCA-M47-2-01 |
| | | | | |
| 2 | 1 | D4006-1 | ANGLE | |
| 3 | 2 | D4006-3 | CHANNEL | |
| 4 | 1 | D4006-5 | FOAM | |
| 5 | 4 | MS20426AD3(-4) | RIVET | |
| 6 | 8 | MS20470AD4(-5) | RIVET | |
| 7 | 2 | MS21059-4 | ANCHOR NUT | |




D4006-041 TANK TOP SUPPORT ASSEMBLY

M0 87702

RELEASED 2012-03-02

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| B | CHANGE POWDER COAT FROM "GREY SANDTEX" TO "ANSI 61 GREY", ZN A7-1. | DC | 12.02.28 |
| A | NEW ISSUE | | 10.02.05 |

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 (B)
BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.48 lbs

| | |
|---|---|
| DESIGN | |
| DRAWN | |
| CHECKED | |
| MFG. APPR. | |
| APPROVED | |
| DE APPR. | |
| DATE | 12.02.28 |

**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4006 — REV. B — SHEET 1 OF 6

TITLE: UPPER RESTRAINT — SCALE: NTS

DQA: ________ Date: ______________

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

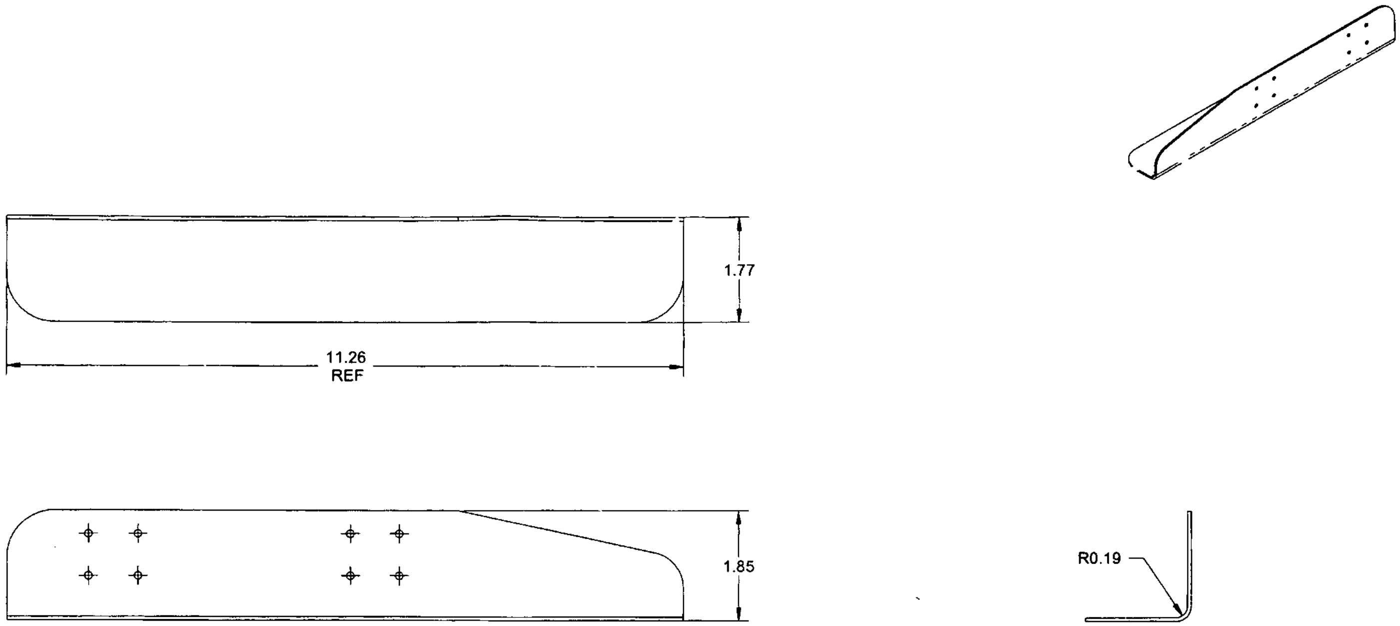
| Work Order: ______ <br> Part No. ______ <br> NCR No. ______ | **DISPOSITION** <br> Rework ☐ <br> Scrap ☐ <br> Use-as-is ☐ <br> Work Order Update ☐ | **AGAINST DEPARTMENT/PROCESS** <br> Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ <br> Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ <br> Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ <br> Large Fab ☐ Composite ☐ Supplier ☐ ☐ |
|---|---|---|

| **Root Cause** | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|
| Doc/Data ☐ | | | | | | | | | |
| Equip/Tooling ☐ | | | | | | | | | |
| Operator ☐ | | | | | | | | | |
| Material ☐ | | | | | | | | | |
| Setup ☐ | | | | | | | | | |
| Other ☐ | | | | | | | | | |
| Process ☐ | | | | | | | | | |
| Supplier ☐ | | | | | | | | | |
| Training ☐ | | | | | | | | | |
| Unapproved ☐ | | | | | | | | | |

## FAULT CATEGORY

| **Landing Gear** | **General** | | | |
|---|---|---|---|---|
| ☐ Bending | ☐ Bend | ☐ Grain | ☐ Ovalized | ☐ Pressure/Forced |
| ☐ Centre Not Concentric to O/S | ☐ BOM/Route | ☐ Hardware | ☐ Over/Under tolerance | ☐ Temperature/Cure |
| ☐ Cracks | ☐ Broken/Damaged | ☐ Inspection Incomplete | ☐ Part Incorrect | ☐ Weld |
| ☐ Crushed/Crimped | ☐ Burrs | ☐ Instructions Incomplete/Unclear | ☐ Part Lost/Missing | ☐ Wrong Stock Pulled |
| ☐ Cuffs | ☐ Contamination | ☐ Maintenance | ☐ Part Moved | |
| ☐ Heat Treat | ☐ Countersink | ☐ Mislabeled | ☐ Positioned Wrong | |
| ☐ Inspection Strip in Tube | ☐ Cut Too Short | ☐ Misread | ☐ Power Loss/Surge | ☐ Other |
| ☐ Ripples in Bend | ☐ Drill Holes | ☐ Offset | ______ | |
| ☐ Torque Waves in Extrusion | ☐ Drawing | ☐ Out of Calibration | ______ | |
| ☐ Turning Sequence | ☐ Finish | ☐ Out of Sequence | ______ | |
| ☐ Wave/Twist in Tube | ☐ Folio | ☐ Outside Dimensions | | |

| DART AEROSPACE PART NUMBER | JOHN CAMERON AVIATION PART NUMBER |
|---|---|
| D4006-1 | REF JCA-M47-2-01 |




**D4006-1 ANGLE**



NOTES:
1) MATERIAL: MADE FROM D4006-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.23 lbs

| DESIGN | | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|---|---|---|
| DRAWN | BC | DRAWING NO. D4006 — REV. B — SHEET 2 OF 6 |
| CHECKED | | |
| MFG. APPR. | | |
| APPROVED | | TITLE UPPER RESTRAINT — SCALE NTS |
| DE APPR. | | |
| DATE | 12.02.28 | |

DQA: ________ Date: ________________

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

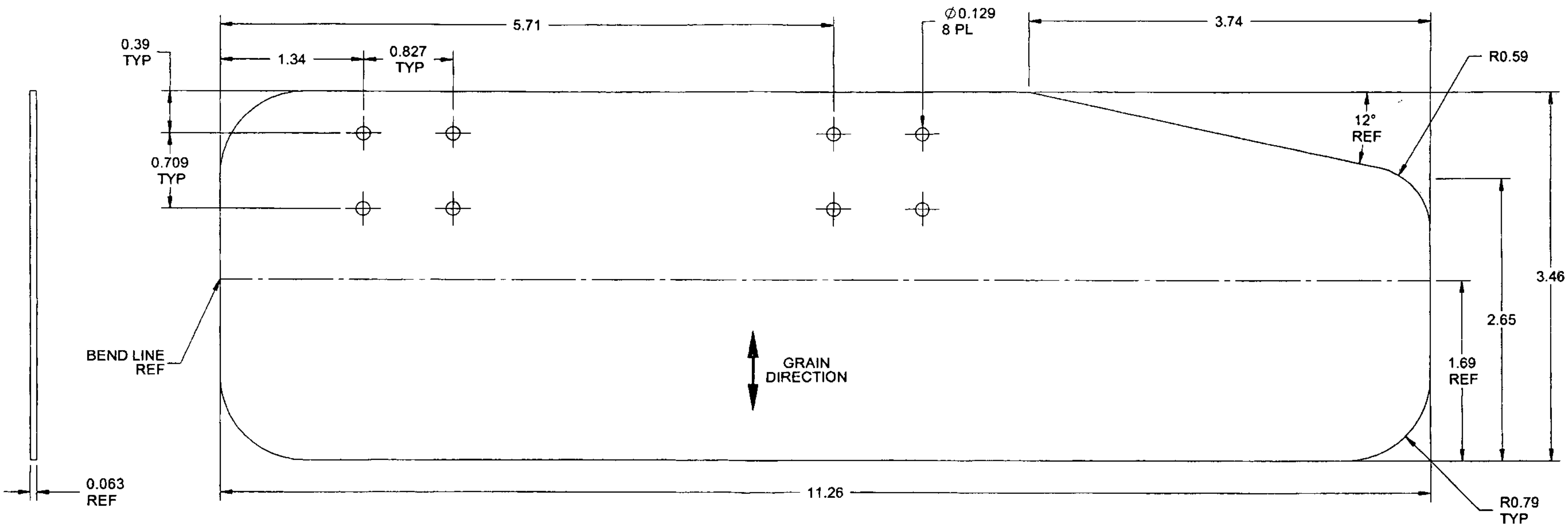
QA Closed: Date:

| | DISPOSITION | AGAINST DEPARTMENT/PROCESS | | | |
|---|---|---|---|---|---|
| Work Order: ____________ | Rework ☐ | Skid-tube ☐ | Crosstube ☐ | Water Jet ☐ | Engineering ☐ |
| Part No. ____________ | Scrap ☐ | Machining ☐ | Small Fab ☐ | Prod. Eng. Coor. ☐ | Quality ☐ |
| | Use-as-is ☐ | Thermoforming ☐ | Finishing ☐ | Rec/Store/Packaging ☐ | Other ☐ |
| NCR No. ____________ | Work Order Update ☐ | Large Fab ☐ | Composite ☐ | Supplier ☐ | ☐ |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|
| Doc/Data ☐ | | | | | | | | | |
| Equip/Tooling ☐ | | | | | | | | | |
| Operator ☐ | | | | | | | | | |
| Material ☐ | | | | | | | | | |
| Setup ☐ | | | | | | | | | |
| Other ☐ | | | | | | | | | |
| Process ☐ | | | | | | | | | |
| Supplier ☐ | | | | | | | | | |
| Training ☐ | | | | | | | | | |
| Unapproved ☐ | | | | | | | | | |

**FAULT CATEGORY**

| Landing Gear | General | | | |
|---|---|---|---|---|
| ☐ Bending | ☐ Bend | ☐ Grain | ☐ Ovalized | ☐ Pressure/Forced |
| ☐ Centre Not Concentric to O/S | ☐ BOM/Route | ☐ Hardware | ☐ Over/Under tolerance | ☐ Temperature/Cure |
| ☐ Cracks | ☐ Broken/Damaged | ☐ Inspection Incomplete | ☐ Part Incorrect | ☐ Weld |
| ☐ Crushed/Crimped | ☐ Burrs | ☐ Instructions Incomplete/Unclear | ☐ Part Lost/Missing | ☐ Wrong Stock Pulled |
| ☐ Cuffs | ☐ Contamination | ☐ Maintenance | ☐ Part Moved | |
| ☐ Heat Treat | ☐ Countersink | ☐ Mislabeled | ☐ Positioned Wrong | |
| ☐ Inspection Strip in Tube | ☐ Cut Too Short | ☐ Misread | ☐ Power Loss/Surge | ☐ Other |
| ☐ Ripples in Bend | ☐ Drill Holes | ☐ Offset | ________ | |
| ☐ Torque Waves in Extrusion | ☐ Drawing | ☐ Out of Calibration | ________ | |
| ☐ Turning Sequence | ☐ Finish | ☐ Out of Sequence | ________ | |
| ☐ Wave/Twist in Tube | ☐ Folio | ☐ Outside Dimensions | | |




**D4006-1F FLAT PATTERN**

RELEASED 2012-03-02

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.23 lbs

| DESIGN | | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|---|---|---|
| DRAWN | | |
| CHECKED | | DRAWING NO. D4006 — REV. B — SHEET 3 OF 6 |
| MFG. APPR. | | |
| APPROVED | | TITLE: UPPER RESTRAINT — SCALE: NTS |
| DE APPR. | | |
| DATE | 12.02.28 | |

DQA: ________ Date: ____________

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

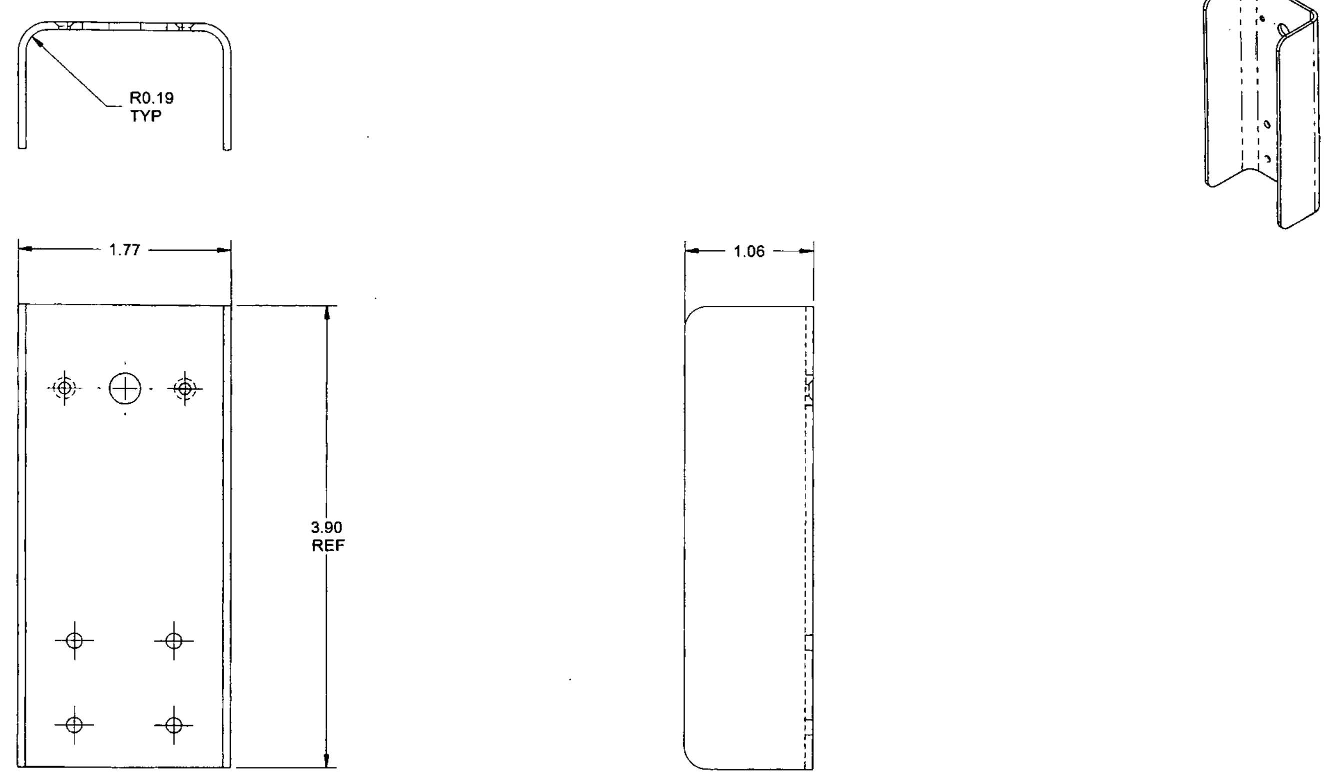
| Work Order: ______ | **DISPOSITION** | **AGAINST DEPARTMENT/PROCESS** | | | |
|---|---|---|---|---|---|
| Part No. ______ | Rework ☐ | Skid-tube ☐ | Crosstube ☐ | Water Jet ☐ | Engineering ☐ |
| NCR No. ______ | Scrap ☐ | Machining ☐ | Small Fab ☐ | Prod. Eng. Coor. ☐ | Quality ☐ |
| | Use-as-is ☐ | Thermoforming ☐ | Finishing ☐ | Rec/Store/Packaging ☐ | Other ☐ |
| | Work Order Update ☐ | Large Fab ☐ | Composite ☐ | Supplier ☐ | ☐ |

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

| **Landing Gear** | **General** | | | |
|---|---|---|---|---|
| ☐ Bending | ☐ Bend | ☐ Grain | ☐ Ovalized | ☐ Pressure/Forced |
| ☐ Centre Not Concentric to O/S | ☐ BOM/Route | ☐ Hardware | ☐ Over/Under tolerance | ☐ Temperature/Cure |
| ☐ Cracks | ☐ Broken/Damaged | ☐ Inspection Incomplete | ☐ Part Incorrect | ☐ Weld |
| ☐ Crushed/Crimped | ☐ Burrs | ☐ Instructions Incomplete/Unclear | ☐ Part Lost/Missing | ☐ Wrong Stock Pulled |
| ☐ Cuffs | ☐ Contamination | ☐ Maintenance | ☐ Part Moved | |
| ☐ Heat Treat | ☐ Countersink | ☐ Mislabeled | ☐ Positioned Wrong | |
| ☐ Inspection Strip in Tube | ☐ Cut Too Short | ☐ Misread | ☐ Power Loss/Surge | ☐ Other |
| ☐ Ripples in Bend | ☐ Drill Holes | ☐ Offset | | |
| ☐ Torque Waves in Extrusion | ☐ Drawing | ☐ Out of Calibration | | |
| ☐ Turning Sequence | ☐ Finish | ☐ Out of Sequence | | |
| ☐ Wave/Twist in Tube | ☐ Folio | ☐ Outside Dimensions | | |

| DART AEROSPACE PART NUMBER | JOHN CAMERON AVIATION PART NUMBER |
|---|---|
| D4006-3 | REF JCA-M47-2-01 |




**D4006-3 CHANNEL**



NOTES:
1) MATERIAL: MADE FROM D4006-3F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.08 lbs

| DESIGN | | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|---|---|---|
| DRAWN | | |
| CHECKED | | DRAWING NO. D4006 — REV. B — SHEET 4 OF 6 |
| MFG. APPR. | | |
| APPROVED | | TITLE UPPER RESTRAINT — SCALE NTS |
| DE APPR. | | |
| DATE | 12.02.28 | |

DQA: ________ Date: ______________

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

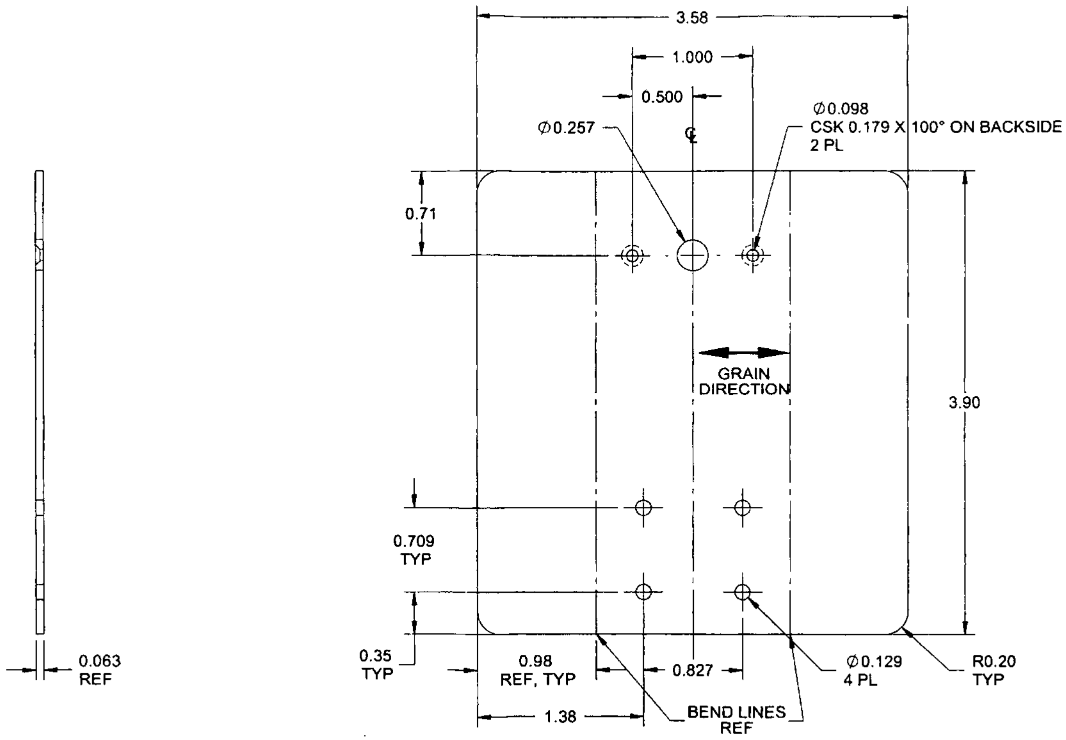
QA Closed: Date:

| Work Order: ____________ <br> Part No. ____________ <br> NCR No. ____________ | **DISPOSITION** <br> Rework ☐ <br> Scrap ☐ <br> Use-as-is ☐ <br> Work Order Update ☐ | **AGAINST DEPARTMENT/PROCESS** <br> Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ <br> Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ <br> Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ <br> Large Fab ☐ Composite ☐ Supplier ☐ ☐ |
|---|---|---|

| **Root Cause** | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|
| Doc/Data ☐ | | | | | | | | | |
| Equip/Tooling ☐ | | | | | | | | | |
| Operator ☐ | | | | | | | | | |
| Material ☐ | | | | | | | | | |
| Setup ☐ | | | | | | | | | |
| Other ☐ | | | | | | | | | |
| Process ☐ | | | | | | | | | |
| Supplier ☐ | | | | | | | | | |
| Training ☐ | | | | | | | | | |
| Unapproved ☐ | | | | | | | | | |

**FAULT CATEGORY**

| **Landing Gear** | **General** | | | |
|---|---|---|---|---|
| ☐ Bending | ☐ Bend | ☐ Grain | ☐ Ovalized | ☐ Pressure/Forced |
| ☐ Centre Not Concentric to O/S | ☐ BOM/Route | ☐ Hardware | ☐ Over/Under tolerance | ☐ Temperature/Cure |
| ☐ Cracks | ☐ Broken/Damaged | ☐ Inspection Incomplete | ☐ Part Incorrect | ☐ Weld |
| ☐ Crushed/Crimped | ☐ Burrs | ☐ Instructions Incomplete/Unclear | ☐ Part Lost/Missing | ☐ Wrong Stock Pulled |
| ☐ Cuffs | ☐ Contamination | ☐ Maintenance | ☐ Part Moved | |
| ☐ Heat Treat | ☐ Countersink | ☐ Mislabeled | ☐ Positioned Wrong | |
| ☐ Inspection Strip in Tube | ☐ Cut Too Short | ☐ Misread | ☐ Power Loss/Surge | ☐ Other |
| ☐ Ripples in Bend | ☐ Drill Holes | ☐ Offset | ____________ | |
| ☐ Torque Waves in Extrusion | ☐ Drawing | ☐ Out of Calibration | ____________ | |
| ☐ Turning Sequence | ☐ Finish | ☐ Out of Sequence | ____________ | |
| ☐ Wave/Twist in Tube | ☐ Folio | ☐ Outside Dimensions | | |




**D4006-3F FLAT PATTERN**

RELEASED 2012-03-02

NOTES:

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
   PER QQ-A-250/4 OR AMS-QQ-A-250/4
   OR AMS 4037 OR ASTM B209
   REF DART SPEC M2024T3S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.08 lbs

| | | |
|---|---|---|
| DESIGN | | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | | |
| CHECKED | | DRAWING NO. D4006 — REV. B — SHEET 5 OF 6 |
| MFG. APPR. | | |
| APPROVED | | TITLE UPPER RESTRAINT — SCALE NTS |
| DE APPR. | | |
| DATE | 12.02.28 | |

DQA: ________ Date: ______________

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

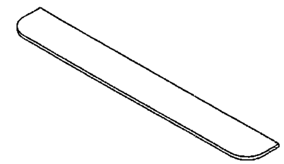
| | | | |
|---|---|---|---|
| Skid-tube ☐ | Crosstube ☐ | Water Jet ☐ | Engineering ☐ |
| Machining ☐ | Small Fab ☐ | Prod. Eng. Coor. ☐ | Quality ☐ |
| Thermoforming ☐ | Finishing ☐ | Rec/Store/Packaging ☐ | Other ☐ |
| Large Fab ☐ | Composite ☐ | Supplier ☐ | ☐ |

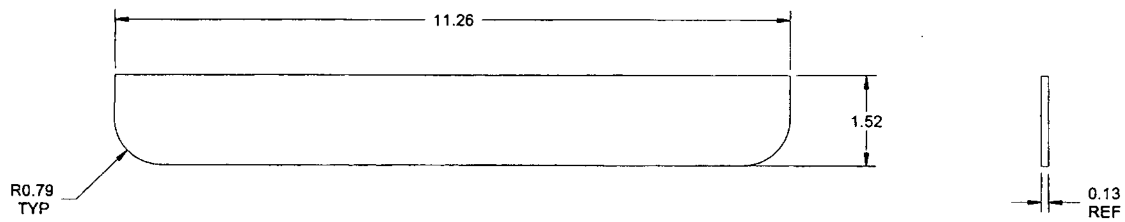
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|
| Doc/Data ☐ | | | | | | | | | |
| Equip/Tooling ☐ | | | | | | | | | |
| Operator ☐ | | | | | | | | | |
| Material ☐ | | | | | | | | | |
| Setup ☐ | | | | | | | | | |
| Other ☐ | | | | | | | | | |
| Process ☐ | | | | | | | | | |
| Supplier ☐ | | | | | | | | | |
| Training ☐ | | | | | | | | | |
| Unapproved ☐ | | | | | | | | | |

**FAULT CATEGORY**

| Landing Gear | General | | | |
|---|---|---|---|---|
| ☐ Bending | ☐ Bend | ☐ Grain | ☐ Ovalized | ☐ Pressure/Forced |
| ☐ Centre Not Concentric to O/S | ☐ BOM/Route | ☐ Hardware | ☐ Over/Under tolerance | ☐ Temperature/Cure |
| ☐ Cracks | ☐ Broken/Damaged | ☐ Inspection Incomplete | ☐ Part Incorrect | ☐ Weld |
| ☐ Crushed/Crimped. | ☐ Burrs | ☐ Instructions Incomplete/Unclear | ☐ Part Lost/Missing | ☐ Wrong Stock Pulled |
| ☐ Cuffs | ☐ Contamination | ☐ Maintenance | ☐ Part Moved | |
| ☐ Heat Treat | ☐ Countersink | ☐ Mislabeled | ☐ Positioned Wrong | |
| ☐ Inspection Strip in Tube | ☐ Cut Too Short | ☐ Misread | ☐ Power Loss/Surge | ☐ Other ____________ |
| ☐ Ripples in Bend | ☐ Drill Holes | ☐ Offset | ____________ | |
| ☐ Torque Waves in Extrusion | ☐ Drawing | ☐ Out of Calibration | ____________ | |
| ☐ Turning Sequence | ☐ Finish | ☐ Out of Sequence | ____________ | |
| ☐ Wave/Twist in Tube | ☐ Folio | ☐ Outside Dimensions | | |

| DART AEROSPACE PART NUMBER | JOHN CAMERON AVIATION PART NUMBER |
|---|---|
| D4006-5 | REF JCA-M47-2-01 |






**D4006-5 FOAM**



NOTES:
1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET, 0.125 THICK
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1
REF DART SPEC M-4111N-S.125
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.08 lbs

| | | |
|---|---|---|
| DESIGN | | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| DRAWN | | |
| CHECKED | | DRAWING NO. D4006 REV. B SHEET 6 OF 6 |
| MFG. APPR. | | |
| APPROVED | | TITLE UPPER RESTRAINT SCALE NTS |
| DE APPR. | | |
| DATE | 12.02.28 | |

DQA: ________ Date: ______________

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

| Work Order: ______ | DISPOSITION | AGAINST DEPARTMENT/PROCESS | | | |
|---|---|---|---|---|---|
| Part No. ______ | Rework ☐ | Skid-tube ☐ | Crosstube ☐ | Water Jet ☐ | Engineering ☐ |
| NCR No. ______ | Scrap ☐ | Machining ☐ | Small Fab ☐ | Prod. Eng. Coor. ☐ | Quality ☐ |
| | Use-as-is ☐ | Thermoforming ☐ | Finishing ☐ | Rec/Store/Packaging ☐ | Other ☐ |
| | Work Order Update ☐ | Large Fab ☐ | Composite ☐ | Supplier ☐ | ☐ |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|
| Doc/Data ☐ | | | | | | | | | |
| Equip/Tooling ☐ | | | | | | | | | |
| Operator ☐ | | | | | | | | | |
| Material ☐ | | | | | | | | | |
| Setup ☐ | | | | | | | | | |
| Other ☐ | | | | | | | | | |
| Process ☐ | | | | | | | | | |
| Supplier ☐ | | | | | | | | | |
| Training ☐ | | | | | | | | | |
| Unapproved ☐ | | | | | | | | | |

## FAULT CATEGORY

| Landing Gear | General | | | |
|---|---|---|---|---|
| ☐ Bending | ☐ Bend | ☐ Grain | ☐ Ovalized | ☐ Pressure/Forced |
| ☐ Centre Not Concentric to O/S | ☐ BOM/Route | ☐ Hardware | ☐ Over/Under tolerance | ☐ Temperature/Cure |
| ☐ Cracks | ☐ Broken/Damaged | ☐ Inspection Incomplete | ☐ Part Incorrect | ☐ Weld |
| ☐ Crushed/Crimped | ☐ Burrs | ☐ Instructions Incomplete/Unclear | ☐ Part Lost/Missing | ☐ Wrong Stock Pulled |
| ☐ Cuffs | ☐ Contamination | ☐ Maintenance | ☐ Part Moved | |
| ☐ Heat Treat | ☐ Countersink | ☐ Mislabeled | ☐ Positioned Wrong | |
| ☐ Inspection Strip in Tube | ☐ Cut Too Short | ☐ Misread | ☐ Power Loss/Surge | ☐ Other |
| ☐ Ripples in Bend | ☐ Drill Holes | ☐ Offset | | |
| ☐ Torque Waves in Extrusion | ☐ Drawing | ☐ Out of Calibration | | |
| ☐ Turning Sequence | ☐ Finish | ☐ Out of Sequence | | |
| ☐ Wave/Twist in Tube | ☐ Folio | ☐ Outside Dimensions | | |